

Classifications

EN ISO 3580-A	AWS A5.5	AWS A5.5M
E ZCrCoW 11 2 2 B 4 2 H5	E9015-B9 (mod.)	E6215-B9 (mod.)

Characteristics and typical fields of application

Boehler FOX C12 CoW is a basic coated core wire alloyed electrode for new creep resistant, tempered 11 % chromium steels, especially for the base material VM12-SHC. Scaling resistant up to 650 °C and high creep rupture strength are quality notes for this electrode.

Base materials

VM12-SHC (X12CrCoWVNb12-2-2)

Typical analysis of all-weld metal (wt.-%)

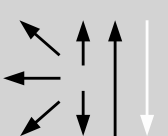
	C	Si	Mn	Cr	Mo	Ni	W	V	N	Co	Nb	B
wt.-%	0.13	0.3	0.5	11.2	0.3	0.4	1.6	0.2	0.05	1.5	0.05	0.002

Mechanical properties of all-weld metal

Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
a	≥ 620	≥ 760	≥ 15	≥ 40

a annealed, 770 °C/2 h

Operating data

	Polarity:	Redrying if necessary:	Electrode identification:	ø (mm)	L mm	Amps A
	DC (+)			2.5	300	70 – 100
		300 – 350 °C / min. 2 h	FOX C12 CoW E	3.2	350	90 – 140
			ZCrCoW 11 2 2 B	4.0	350	130 – 180

Preheating: 150 – 200 °C

Interpass temperature: 200 – 280 °C.

Approvals

TÜV (10579.), CE